

Work Order ID 83455

Wednesday, April 18, 2012 8:43:50 AM

83455

Page 1

Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft In 205
 Start Date: 4/18/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/18 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2574	Rev E								

100
100
 HAAS 1
 HAAS CNC vertical machine #1
 HAAS CNC VERTICAL MACHINING #1
 Memo
 Program Batch No. 83455 Double check by: HA 1-Machine Step
 No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
 Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-
 Machine Step No 3 per Folio FA051 and insp
 0.00 HA 12/05/06
 12 0 1

110
110
 Mill Conv
 Conventional Milling Machine
 CONVENTIONAL MILLING MACHINE
 Memo
 Machine keyway as per dwg D2573 & D2574
 0.00 HA 12/05/07
 12 0

120
120
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo
 0.00 HA 12/05/07
 12 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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 Start Date: 4/18/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	12-05-14					
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ FINISH TIME: _____ 3200F	0.00 0.00							

12-05-14

12 X

12/05/17

m121134

7:30
8:00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83455***83455***

Page 3

Wednesday, April 18, 2012 8:43:50 AM

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Revision ID: Stop ***NS2***
Item Name: Saddle, Aft In 205
Start Date: 4/18/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 4/25/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						12	0		12-5-17
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 433	0.00							
170									
Packaging	Memo	0.00							12/5/12 (12)
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									12/5/22
QC	Memo	0.00							
Quality Control									

12-5-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 18, 2012 8:43:57 AM

Page 1

Work Order ID: 83455

83455

Parent Item: D2574

D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 4/18/2012

Required Date: 4/25/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	49.0000	1	12			
D6101-005									**			12/05/06	
Saddle Billet													

Location	Loc Qty	Loc Code
MAT041	2	
76838	2	
MAT044	47	
79874	19	
81973	28	

→ 83444

12.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	83455
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	.500	.500	.500		
G	0.257	0.262		0.259	.259	.259	.259		
H	0.375	0.380		0.377	.377	.377	.377		
I	0.490	0.510		0.500	.500	.498	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	.568	.566	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.125	.125	.126	.126		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		0.252	.250	.251	.251		
S	0.115	0.135		0.126	.129	.127	.128		
T	0.178	0.198		0.188	.188	.188	.188		
U	3.210	3.250		3.230	3.228	3.230	3.229		
V	0.230	0.250		0.240	.241	.241	.240		
W	0.115	0.135		0.128	.127	.128	.130		
X	0.307	0.312		0.310	.309	.310	.309		
Y	0.760	0.765		0.760	.760	.760	.760		
Z	0.352	0.372		0.370	.366	.368	.369		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.626	.626	.625	.625		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.240	.246	.249	.246		
AE	1.500	1.520		1.512	1.517	1.5135	1.5127		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		0.280	.280	.280	.280		
AH	0.240	0.260		0.250	.247	.249	.247		
AI	2.000	2.020		2.002	2.0012	2.002	2.003		
AJ	0.023	0.043		0.033	.033	.033	.033		
Accept/Reject									

Measured by: BA
Date: 12/05/07

Audited by: JL
Date: 12-05-14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	83455
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.501	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.499	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.567	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.125	.127	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.251	.251		
S	0.115	0.135		.129	.128	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.230	3.230		
V	0.230	0.250		.242	.241	.241	.241		
W	0.115	0.135		.131	.132	.131	.131		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.371	.370	.369	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	.247		
AE	1.500	1.520		1.517	1.512	1.513	1.512		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.280	.280	.280	.280		
AH	0.240	0.260		.248	.248	.247	.247		
AI	2.000	2.020		2.003	2.002	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	AK
Date:	12/05/08

Audited by:	SL
Date:	12-05-11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	83455
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Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	#11	#12		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.501	.501	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.498	.498	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.566	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
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Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.257	.252	.250		
S	0.115	0.135		.127	.127	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.229	3.229	3.229	3.229		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.129	.129	.128	.128		
X	0.307	0.312		.310	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.366	.366	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.247	.246	.246		
AE	1.500	1.520		1.512	1.512	1.513	1.512		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.280	.280	.280	.280		
AH	0.240	0.260		.249	.247	.247	.246		
AI	2.000	2.020		2.003	2.0025	2.004	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	OMK
Date:	12/05/08

Audited by:	SL
Date:	12-05-14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83455 MCT
12/04/18